

Work Order ID 53667

Page 1

November 12, 2009 8:10:21 AM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 12/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 09-11-12 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	Rev E

100



Weld per dwg A/R S.S. rod Batch: 11109123 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

Work Order ID 53667

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Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

→ 12/11/24

0.00

120



QC

Quality Control

Memo

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

+ pressure was set

→ 11/11/26

Memo 11/11/26

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 8:30 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:00 AM

2ND COAT:

START TIME: 9:20 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:50 AM

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinishing

0.00

x1

HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M112623

MD 09/11/27

BLACK spray paint s Batch: M12437

150



QC3- Inspect Part Finish

0.00

BR 09-11-27

QC

Memo

0.00

Quality Control

160



Identify as per dwg & Stock Location: W/0 53646

0.00

Packaging

Memo

0.00

Packaging

① ✓

1 09-11-27

Work Order ID 53667

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Page 4

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Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/01 HJ

PL09-12-1
(1)

Picklist Print

Page 1

November 12, 2009 8:10:29 AM

Work Order ID: 53667



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured		No		100	Each	20.0000	2.0000			

Clevis

W/A

Warehouse

Location

Main Warehouse

ST

20

31101

2

52498

18

ONLY APPLICABLE ON D130-701-041

D2232-1RevC

Manufactured No

100

Each

18.0000 2.0000



Basket Hinge

SAD 09-11-19

Warehouse

Location

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

16

51105

16

(2)

4

Picklist Print

Page 2

November 12, 2009 8:10:29 AM

Work Order ID: 53667



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-1RevD



Manufactured

No

100

Each

33.0000

2.0000



SAP

09-11-19

Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 33

51331 8

52832 25

(2)

D2506RevF



Manufactured

No

100

Each

7.0000

1.0000



SAP

09-11-19

Label Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 1

44275 1

Main Warehouse

WA 6

52834 6

(1)

Picklist Print

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November 12, 2009 8:10:29 AM

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Start Date: 12/11/2009

Required Date: 19/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2581RevA1



Manufactured

No

100

Each

40.0000

2.0000



SAD

09-11-19

Mounting Bracket

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	9	

Main Warehouse

WA	28	
50872	1	
51745	27	

D3166-3RevA1



Manufactured

No

100

Each

5.8632

1.0000



SAD

09-11-19

Basket Hoop

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

WA	5.8632	
50033	0.0527	
50618	0.1894	
52058	5.6211	

Picklist Print

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November 12, 2009 8:10:29 AM

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Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 12/11/2009

Required Date: 19/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F 		Purchased		No		100	sf	176.7895	18.9474		SAD	09-11-19

Expanded Metal Flat SS

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

MAT	176.7895065	
110134	3.4	
111630	1.85	
111956	0.000017	
112147	6.29428947	
112311	0.9205	
112707	28.6203	
112949	135.7044	

1.29428

~~112147~~ 13.65312

M304TS0.750W.065

Purchased

No

304 SQ Tube .75x.75x.065W

100 f 479.3370 45.8741



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

MAT	473.6842	
113082	473.6842	

45.8741

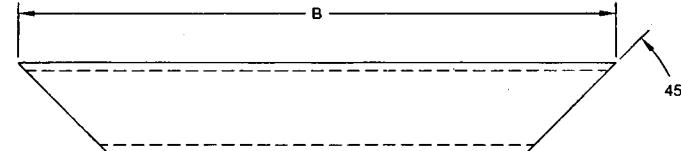
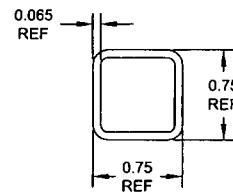
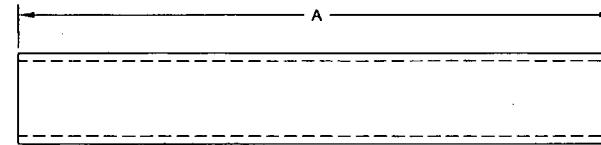
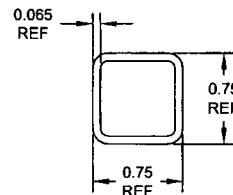
Main Warehouse

WA	5.6527947	
112398	5.6527947	

8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

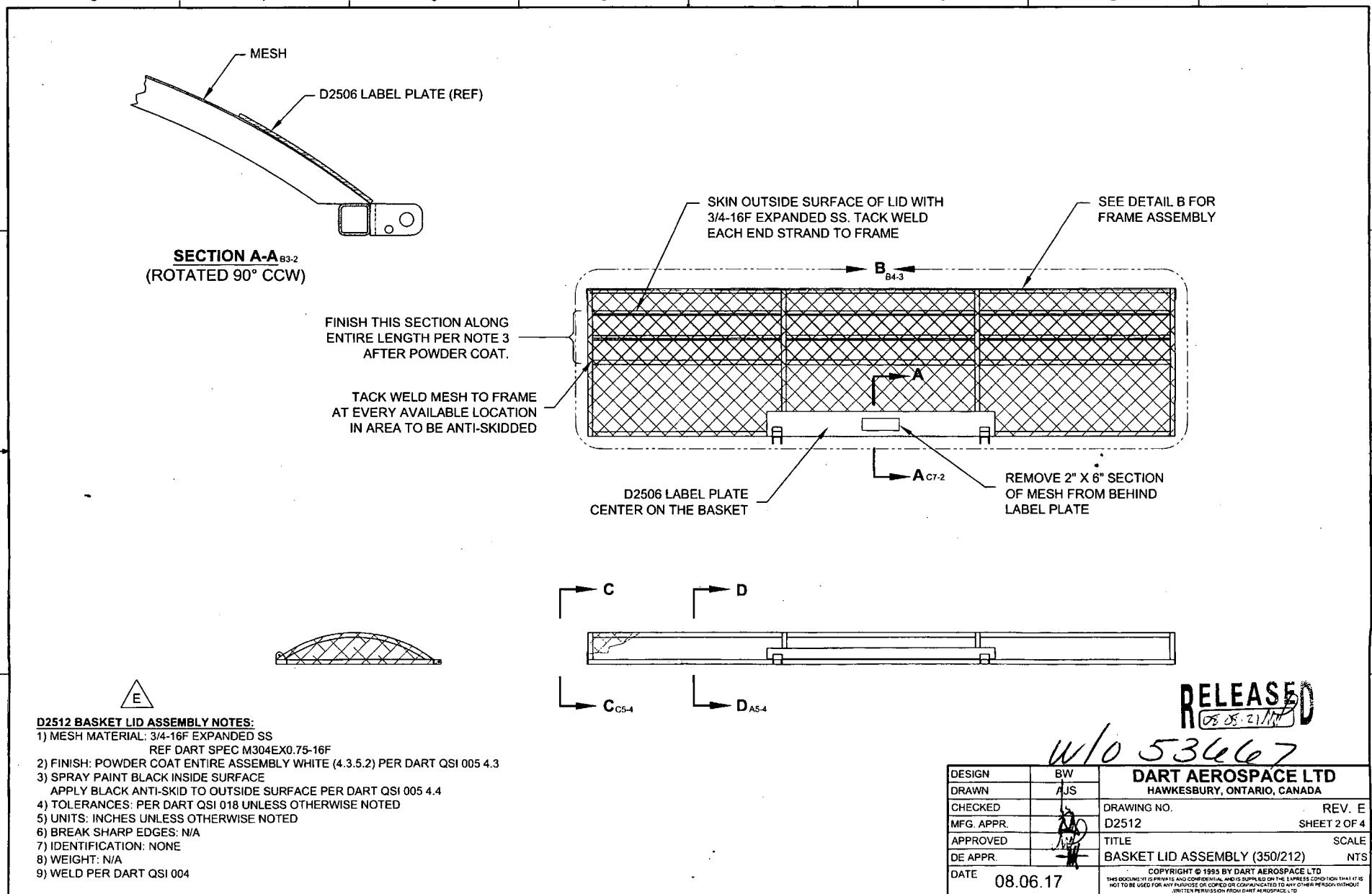
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53667

PL 09-11-12

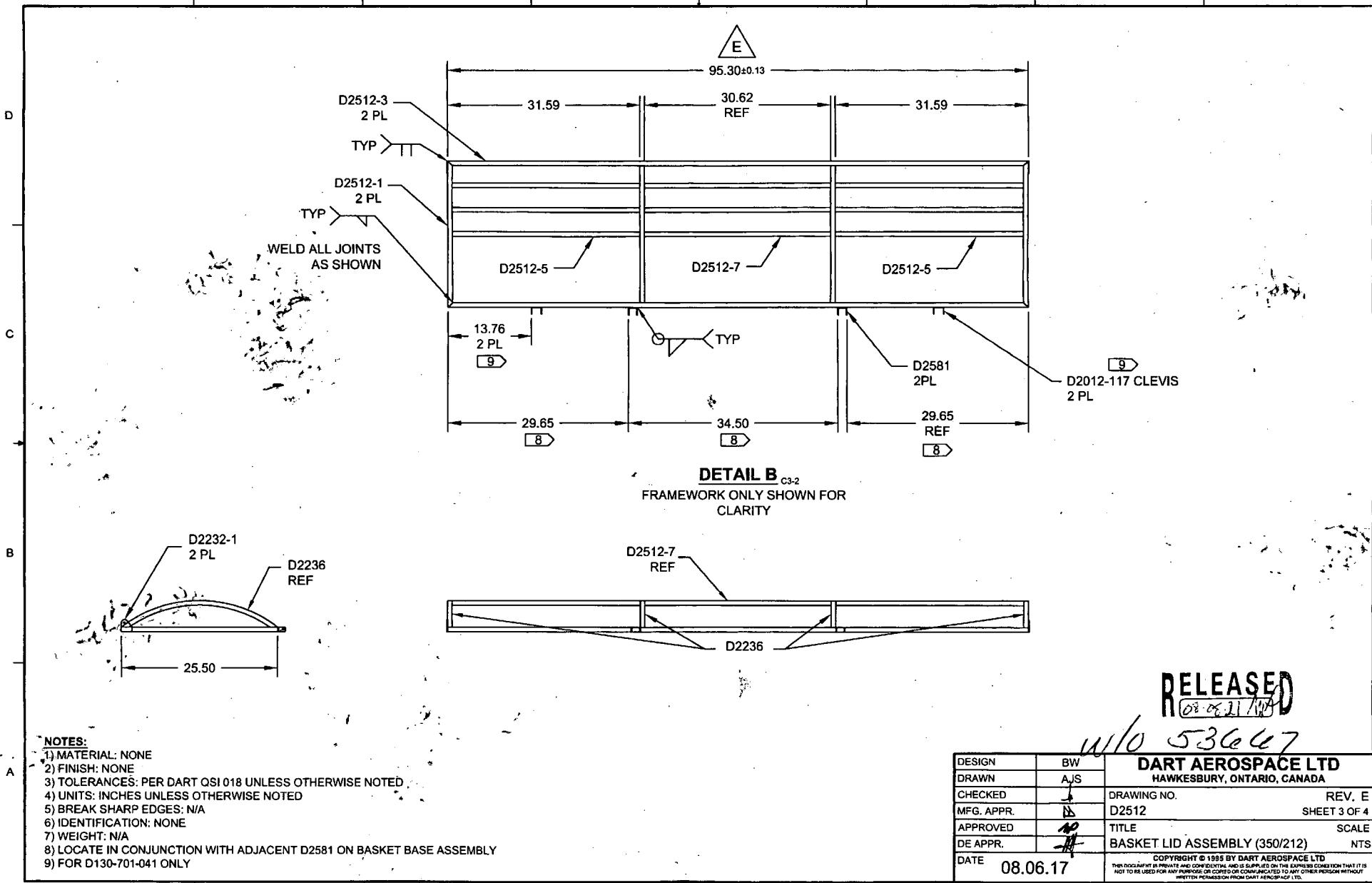
RELEASED
08-08-21/17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCOR DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO. REV. E	
CHECKED		D2512 SHEET 1 OF 4	
MFG. APPR.		TITLE	
APPROVED		SCALE	
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





8 7 6 5 4 3 2 1

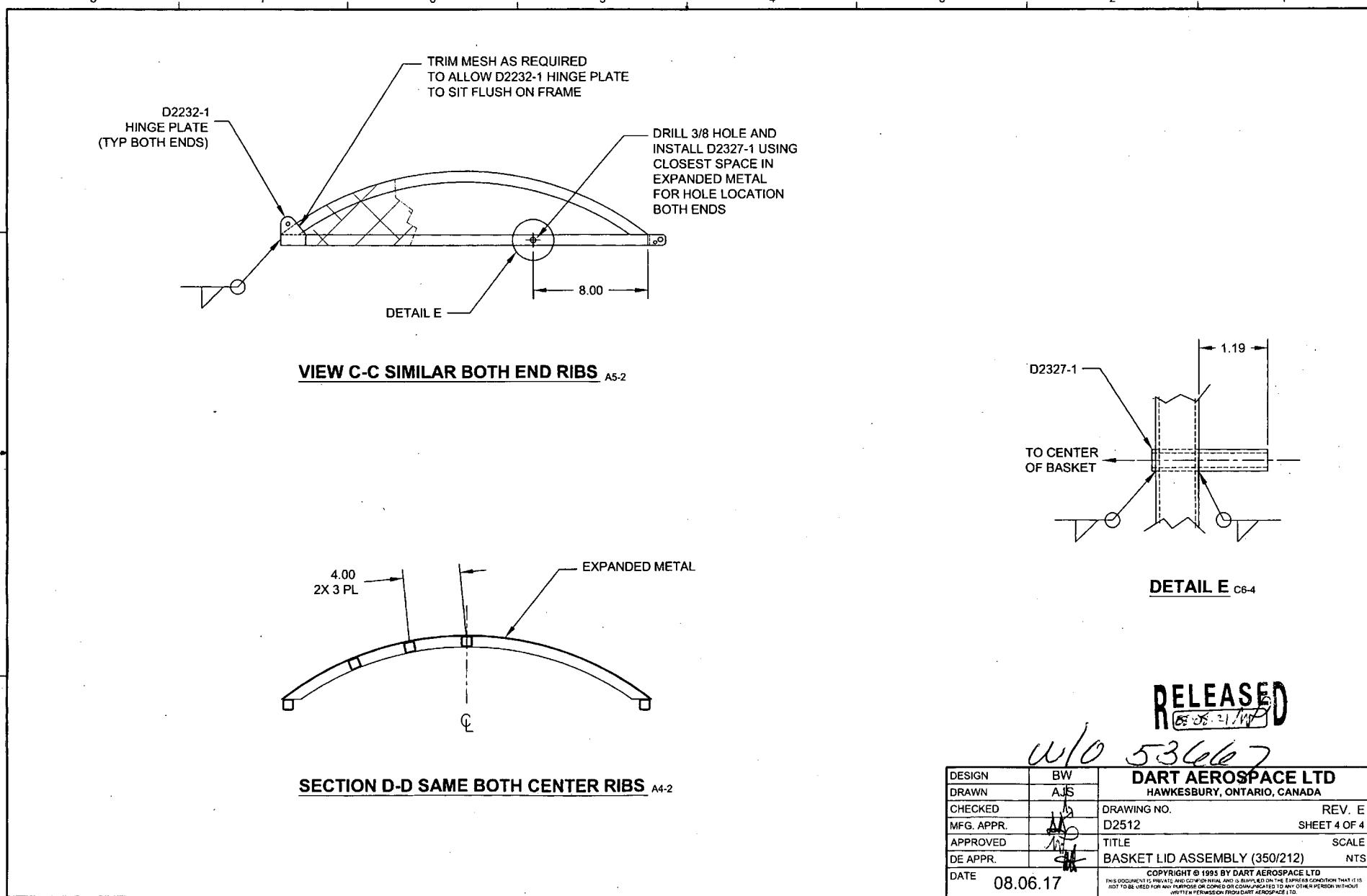


DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. E	
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED	10	TITLE	
DE APPR.	11	SCALE	
DATE	08.06.17	BASKET LID ASSEMBLY (350/212) NTS	

RELEASED
08.06.17
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8 7 6 5 4 3 2 1



DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	DRAWING NO. REV. E
MFG. APPR.	✓	D2512 SHEET 4 OF 4
APPROVED	✓	TITLE SCALE
DE APPR.	✓	BASKET LID ASSEMBLY (350/212) NTS
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